Work Order <i>May-06-14 8:10:1</i>			*119	ივგ*							Page	1
Item ID: D. Revision ID:	3601-1		Accept	*N900	040	100)*	Setup	Start	*N:	S1*	
Item Name: Ra	adius Block	·							Stop	*N:	S2*	
Start Date: 5/	05/14 Start Qty: 40.00	*40*		Cust Item I	D:							
Required Date: 5/0	05/14 Req'd Qty: 40.00	· · · · ·		Customer:								
	Process Plan:	Date: 14-05-0	Tooling:	Da	nte:			Run	Start	*N	R1*	
(QC:	Date:	_ SPC (Y/N):	Da	nte:				Stop	*N	R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej		Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr											
D3601	Rev A											
100 *1 \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	SHEAR Memo		0.00				DAS 02	<u> </u>	14	- OS	-29	X
Shear		10" long +/- 0.030"Note: 1 bl	-			-	9-89					
110			0.00				DAS 02				_	1
110	HAAS CNC VERTICA	AL MACHINING #1	0.00				9-89	BI		1-04	70	(K
HAAS CNC vertical ma	Memo 1- Mill as	per Folio FA682 Rev: AF	0.00 & Dwg D3601 Rev:	1								
. 120	QC2- Inspect parts off	machine FAI/FAIB	0.00				DAS					
1 20	Memo		0.00				02 9-89	ET		1-05	-20	_

Memo

Quality Control

WORK ORDER NON-CONFORMANCE / UPDATE Work Order: Date: Work Order update or Work Order: Skid-tube	
Work Order: Skid-tube Crosstube Water	nly
Rework Skid-tube Crosstube Water Scrap Machining Small Fab Prod. Eng. 0	:ss
Root Description of work order update Initial Action Sign &	
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	ication QC Inspector
FAULT CATEGORY	
Landing Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crüshing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Bend Bend Bend Folio/Program Grain Folio/Program Goutside Dimensions Folio/Program Goutside Dimensions Folio/Program Goutside Dimensions Grain Folio/Program Goutside Dimensions Folio/Program Goutside Dimensions Grain Folio/Program Goutside Dimensions Goutside Dimension	⊢

Work Ord May-06-14 8:1		9038			*110				Page 2			
Item ID: Revision ID: Item Name:	D3601-1 Radius Block				Accept	*N900	040	100	* 5	Setup Sta	1 7	S1* S2*
Start Date: Required Date Reference:	5/05/14 :: 5/05/14	Start Qty: 40.00 Req'd Qty: 40.00		*40* *40*		Cust Item I	ID:					
Approvals:	Process Pla	n:	Date:		Tooling: SPC (Y/N):		ate:		F	Run Sta St	/ 	R1* R2*
Sequence ID/ Work Center I 130 *1 20* QC Quality Control	ID	Operation Description QC8- Inspect parts - se	cond check		Set Up/ Run Hours 0.00	Tool ID		Code	Accept Qty 45	Reject Qty	Reject Number	Insp. Stamp
140 *1 4 0 * Small Fab Small Fab		Small Fab Memo 1-Tumble 2-Deburr		ges after tumblir	0.00 0.00		44 H	4 14 E	14X 63			14/06/0

44 76146-4

0.00

0.00

150

150 HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

DQA:			Date:		·								
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	er:					DISPOSITION			AGAIN	NST DE	PARTMENT	PROCESS	
Work Orac						Rework	1	Skid-tube Crosstube			1	Water Jet	Engineering
Part N	lo.					Scrap	1	,	Machining Small I	_	Pro	d. Eng. Coor.	Quality
	•		······································			Use-as-is		l .	noforming Finish	ing	4	e/Packaging	Other
NCR I	۱o.					Suspected Unapproved]	Large Fab Composite]	Supplier	
Root					Desci	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup											İ		
Process							ĺ						
Supplier													ļ
Training _													
Transport													
Unapproved		•					<u> </u>	UT CAT	L TEGORY				L
Landi	200					General	FA	OLI CA	IEGORT				· <u> </u>
Laitui	ig (Bending				Bend		leolio/E	Program		Outside Dim	ensions T	Pressure/Forced
		Centre No	nt Concer	ntric	-	BOM/Route	\vdash	Grain	Togram	-	Over/Under	 	Set-up
		Cracks	or concer	itiic	-	Broken/Damage/Defect	-	Hardwa	nre		Part Incorred	 	Temperature/Cure
		Crimp/Kir	k/Ripple	/Wave		Burrs		ł	ion Incomplete/Unqualified		Part Lost/Mi	-	Weld
	_	Cuffs		,		Contamination	\vdash	1	tions Incomplete/Unclear		Part Moved	Ť	Wrong Stock Pulled
		Crushing			 	Countersink		4	ned/off center		Positioned V	∟ Vrong	-
:	-	Heat Trea	it			Cut Too Short		Mislabe			Power Loss/		Other
	-	Inspection		Tube		Drawing		Misread	d	1			
		Marks/Ch	-			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence				

Work Order ID 119038 *119038* Page 3 May-06-14 8:10:13 AM D3601-1 Accept *N900040100* Item ID: Setup Start Revision ID: Stop Radius Block Item Name: **Start Otv:** 40.00 *40* Start Date: 5/05/14 **Cust Item ID:** Reg'd Otv: 40.00 Required Date: 5/05/14 *40* **Customer:** Reference: Run Start Process Plan: Date: Tooling: Date: **Approvals:** Stop Date: SPC (Y/N): Date: OC: Reject Sequence ID/ Tool ID Tool # Plan Reject Insp. Operation Set Up/ Accept Number Stamp Oty Oty Work Center ID Description Code Run Hours 160 OC3- Inspect Part Finish 0.00 *160* OC Memo Quality Control Identify as per dwg & Stock Location: 5705/ 0.00 170 *170* JUN 0 4 2014 0.00 Packaging Memo Packaging 180 QC21- Final Inspection - Work Order Release 0.00 MCD 140604 MF, 4-6-4 *120* 0.00 QC Memo Quality Control

DQA:			Date:											
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			_		AEROSPACE
QA Closed:			Date:			10.00000 1 20.0 1 20				W	ork Order u	odate only		
Work Orde	or.					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
Work Ora	•					Rework		Skid-tube Crosstube]	Water Jet	٦	Engineering
Part i	lo.					Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	7	Quality
	•					Use-as-is			moforming Finishing		ł	re/Packaging	7	Other
NCR I	No.					Suspected Unapproved	ted Unapproved Large Fab Composite				Supplier			
Root			-		Desci	ription of work order update		nitial	Action		Sign &	·		··· ,,
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification		QC Inspector
Design														
Doc/Data	\Box													
Equip/Tooling														
Handling/Pre	Щ													
Material														
Operator														رام سید د دواران
Offset/Setup												•		The state of the s
Process														9)
Supplier														, ··•
Training												-		•
Transport	Н	/												
Unapproved			<u> </u>				FΔI	III T CA	TEGORY			. <u> </u>		
Landi	ng G	Gear				General	17.	oei on	1200111					
20.10.		Bending				Bend] Folio/F	Program	Г	Outside Dim	ensions	\neg_{P}	ressure/Forced
	Н	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	⊢	_	et-up
		Cracks				Broken/Damage/Defect	\vdash	Hardwa	are		Part Incorre	}	T	emperature/Cure
		 Crimp/Kir	ık/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified	Г	Part Lost/M	ssing	\neg	Veld
		Cuffs				Contamination		1	tions Incomplete/Unclear	Г	Part Moved		٦v	Vrong Stock Pulled
		Crushing				Countersink		- 4	gned/off center		Positioned V	Vrong	_	
		Heat Trea	it `			Cut Too Short		Mislabe	eled		Power Loss/	Surge	0	ther
		Inspection	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Ch	atter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence					

Picklist Print

May-06-14 8:10:12 AM

Work Order ID: 119038 *119038*

Parent Item:

D3601-1

D3601-1

Parent Item Name: Radius Block

Start Date: 5/05/14

Required Date: 5/05/14

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev:A New Issue 07-03-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1		Purchased	No			f	96.1820	120,	2.664			

M6061T6B00750X00 125

			3-03
Location	Loc Qty	Loc Code	
MAT049	96.182		
M127818	36.182		
M128866	60		× 4.5

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	W	ork Order u	odate only	AEROSPACE	
Mark Orde						DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
Work Orde	er: -					Rework			Skid-tube Crosstube	$\overline{}$	Water Jet Engineering			
Part N	۱o. <u>-</u>					Scrap		Machining Small Fab			4	d. Eng. Coor.	Engineering Quality	
NCR N	No.					Use-as-is Suspected Unapproved		Inerr	noforming Finishing Large Fab Composite	-				
Root					Desci	ription of work order update	n of work order update Initial Action			Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
Design		·		15/	Į.									
Doc/Data			•											
Equip/Tooling					-									
Handling/Pre														
Material														
Operator														
Offset/Setup				,										
Process														
Supplier														
Training														
Transport														
Unapproved							Ì							
							FAI	ULT CA	TEGORY				· .	
Landi	ng G	iear				General		_		_	=		_	
		Bending				Bend		Folio/f	Program	L	Outside Dim	ensions	Pressure/Forced	
		Centre No	ot Concei	ntric		BOM/Route		Grain		L	Over/Under	tolerance	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	cí _	Temperature/Cure	
		Crimp/Kir	ık/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqualified	L	Part Lost/M	issing	Weld	
		Cuffs				Contamination	L	Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled	
		Crushing				Countersink	L	Misali	gned/off center		Positioned V	Vrong	_	
		Heat Trea	it			Cut Too Short		Mislab	eled	L	Power Loss/	Surge	Other	
		Inspection	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Ch	atter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
		Wave/Tw	ist in Tub	be		Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order:	119038
Description: Radius Block	Part Number:	D3601-1
Inspection Dwg: D3601 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	0.745				
0.375	+/-0.010	0.312				
0.375	+/-0.010	0.378				·
Ø0.257	+0.006/-0.001	0.256				
0.357	+/-0.010	0.356				
R0.38	+/-0.030	0.380				
0.80	+/-0.030	0.809				
0.3 x 45°	+/-0.010 x 0.5°	0.040				

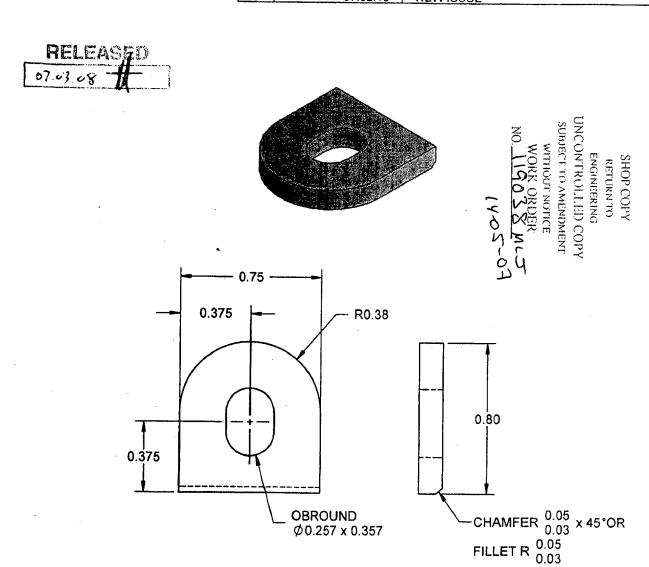
						,
					, , , , , , , , , , , , , , , , , , ,	

DA3				
Measured by: 02	Audited by:	01	Preliminary Approval:	
Date: /4.05 30	Date:	14/0/30	Date:	

Rev	Date	Change	Revised by	Approved
Α (07.05.08	New Issue	KJ/JLM .	11
В	11.08.22	Dimensions updated	KJ K	<i>B</i> 2



DESIGN		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECK	ED	APPROVED	D3601	REV. A SHEET 1 OF 1
07.02.13			RADIUS BLOCK	SCALE 2:1
REV A	DATE 07.02.13		DESCRIPTION NEW ISSUE	



D3601-1 RADIUS BLOCK

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 SHEET, 0.125 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.125) OR
ALUMINUM 6061-T6 SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS 4025/4027

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N "D3601-1" USING FINE POINT PERMANENT INK MARKER
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
6) BREAK ALL SHARP EDGES 0.005 TO 0.050 MAX